Work Orde February-12-14	er ID 113123 8:36:38 AM n. a.	535-15	*113	3123*						Page 1	
	D3535-15 B 1	13123	Accept	*N900	040	100)* s	Setup Star	171	S1*	=
Item Name:	Stainless Steel Wearplate Fwd							Stop	, *N	S2*	
Start Date:	2/18/14 Start Qty: 8.00	极*		Cust Item I	D:						
Required Date:	2/18/14 Req'd Qty: 8.00	*8*		Customer:							
Reference:											
Approvals:	Process Plan: MLJ	Date: 14-02-	(7 Tooling:	D:	ate:		R	Run Star	~I <i>V</i> I	R1*	
	QC:	Date:	SPC (Y/N):	Da	ate:			Stop	' *N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	Revision Nbr										
D3535	Rev B										
100			0.00							_	
100	FLOW WATER JET						_13_	_@		Ac	
Waterjet FLOW CNC Waterje	Memo	D D2525 D D.	0.00 v: • Prog Rev: • 3	5			-,			Ac 28.	- / 9
FLOW CNC waterje		necessary	v:rrog Rev:	5 _2-						•	·
			•								
110	QC2- Inspect parts off	f machine FAI/FAIB	0.00								
*11 0 *			0.00				13	<u> </u>	******	Ae	
QC Quality Control	Memo		0.00					₩ e		Ae 02-28	} -
Quanty Control											
120	QC8- Inspect parts - s	econd check)AS			••				
120 QC	Memo		0.00	27 9-89 3			R				
Quality Control			1 1	راد /							

DQA:			Date:											$\Gamma \mathbb{Q} \wedge \mathbb{C}^{\mathcal{D}}$
						WORK ORDER NON	-CC	ONFO	RMANCE / UF	PDATE				AEROSPACE
QA Closed:		_	Date:							W	ork Order up	date only	\Box	
Work Orde	r.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIK Olde	٠.					Rework	1		Skid-tube	Crosstube]	Water Jet	\neg	Engineering
Part N	o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	ᅱ	Quality
	•					Use-as-is	1		noforming	Finishing	4	re/Packaging	ᅦ	Other
NCR N	ο.					Suspected Unapproved			Large Fab	Composite]	Supplier		
			, ,	,							<u> </u>			
Root					Desc	ription of work order update		nitial	Acti		Sign &			
Cause	\dashv	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	ᆜ	QC Inspector
Design														
Doc/Data	\dashv												İ	
Equip/Tooling	ᅱ													
Handling/Pre Material													ł	
Operator													1	
Offset/Setup	\neg						1							
Process	\dashv													
Supplier					-									
Training							l							
Transport														
Unapproved														
							FA	ULT CA	TEGORY					
Landir						General		7		_	7	-		
]		Bending			_	Bend	_	4	Program		Outside Dim	F		Pressure/Forced
		Centre No	ot Concer	ntric	_	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under		$\overline{}$	Set-up
	_	Cracks	1.40: 1		<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorred	-	-	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave	-	Burrs		1	ion Incomplete/Un	<u> </u>	Part Lost/Mi	· · · · · ·	-	Weld
}		Crushing			-	Countarion	\vdash	4	tions Incomplete/U	Inclear	Part Moved			Wrong Stock Pulled
		Crushing Heat Trea			-	Countersink Cut Too Short		Mislab	gned/off center	\vdash	Positioned V Power Loss/	· ·	\neg	Other
		Inspectio		Tuhe	-	Drawing	\vdash	Misrea		<u>L</u>	Trower ross/	ouige [_	Other
		Marks/Ch	•	, and		Drill Holes		Off-set						
		Turning S			-	Finish		4	Calibration					
		Wave/Tw	•			Fit/Function		4	Sequence					

Work	Orde	r ID	113123	,
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113123

Page 2

February-12-1	4 8:36:38 A	M		1 1 1	11/.1					
Item ID: Revision ID: Item Name:	D3535-15 Stainless Ste	eel Wearplate Fwd		Accept	*N900	0040100	ን *	Setup Star Stoj	171	S1* S2*
Start Date: Required Date Reference:	2/18/14 e: 2/18/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item 1 Customer:	ID:				. 17
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ate:	F	Run Star Stoj	/\!\\	R1* R <i>2</i> *
Sequence ID/ Work Center	ID	Operation Description NC BRAKE		Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp 14/03/8
Brake NC Brake NC		Memo 1-Form on ligger joggle as pe	Brake as per Dwg D3535 r Dwg D3535 using Jig D	0.00 using Jigs DT8261and DT T81583-Identify as D3535	83262-Form 5-15	30 9-89	_()			
¹⁴⁰ *1⊿∩*		QC5- Inspect part comp	leteness to step on W/O	0.00	DAS 27 959		13			
QC Quality Control		Мето		0.00	19/3/9					
150 *150* Powdercoat		••••	6) per OSI005,4.3	0.00			13 g	b_ K	3-//	DAS 34
Powder Coating		Memo START TIA	ME: \$:00 _FINISH TIME:	OVEN TEMPERATURE	i:		,		•	

DQA:			Date:												TRAGE
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UI	PDATE	W	ork Order up	ndate only - [\neg	AEROSPACE
Q, Closed.			Dute.			DISPOSITION				ACAINCT		,	•		
Work Orde	r: _					DISPOSITION				AGAINSI	DE	PARTMENT,	PROCESS _		
			*			Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	o					Scrap		1	Machining	Small Fab		1	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	_	Rec/Sto	re/Packaging	_	Other
NCR N	o. <u> </u>					Suspected Unapproved]		Large Fab	Composite			Supplier		
Root	Т				Desc	ription of work order update		Initial	Act	ion		Sign &			· · · · · · · · · · · · · · · · · · ·
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption		Date	Verification		QC Inspector
Design	_														
Doc/Data	4														
Equip/Tooling	_														
Handling/Pre	_														
Material	_		ļ			•									
Operator							İ								
Offset/Setup	_														
Process	4						1								
Supplier	_														
Training	_														
Transport		4													
Unapproved					<u> </u>	·						<u> </u>			
							FA	ULT CA	regory						
Landin						General		1 <i>.</i> _				1 .	г		
]		Bending			<u> </u>	Bend		4	rogram		<u> </u>	Outside Dim	F-	_	Pressure/Forced
	_	Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	F	_	Set-up
	_	Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa			_	Part Incorre	F		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	<u></u>	4	ion Incomplete/Ur	-		Part Lost/Mi		-	Weld
	— 1	Cuffs				Contamination		-1	tions Incomplete/U	Jnclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		- `	ned/off center		_	Positioned V			
		Heat Trea				Cut Too Short	\vdash	Mislabe				Power Loss/	Surge		Other
ļ Ļ	_	nspectio		Tube		Drawing	<u>_</u>	Misread							
	_	Marks/Ch				Drill Holes	L	Off-set							
		Turning S	equence			Finish		Out of	Calibration						
1	١	Wave/Tw	ist in Tub	ne .		Fit/Function		Out of	Seguence						

Work Ord February-12-14				*1131	123*						Page 3
Item ID: Revision ID:	D3535-15			Accept	*N900	040	100)* s	Setup Sta	rt *N	S1*
Item Name:	Stainless Stee	el Wearplate Fwd							Sto	p */	S2*
Start Date: Required Date Reference:	2/18/14 : 2/18/14	Start Qty: 8.00 Req'd Qty: 8.00	*p		Cust Item I Customer:	D;		_			,
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:		ŀ	Run Sta	^I <i>V</i> I	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		QC3- Inspect Part Finish		0.00				Ы			
1 AN OC Quality Control		Мето		0.00 27 9-89 14/3/))			<u>/></u>			-
170		Identify as per dwg & Stoo	ck Location:)-00Z 0.00					ſ	H	1 ,
170 Packaging Packaging		Memo		0.00				<u>x 13</u>	<u> </u>	<u> </u>	14/03/

180

QC21- Final Inspection - Work Order Release

0.00

1 20

Memo

0.00

Quality Control

MLJ 1403-12 MF 14-3-11

DQA:		Date:			•			_				TRAC
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPI		ork Order up	odate only	AEROSPACE
Work Order					DISPOSITION		·			EPARTMENT,	· · · · · · · · · · · · · · · · · · ·	
Work Order Part No NCR No).				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	⊣	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
		·	•			1	<u></u>	, u				
Root Cause	Date	Step	Qty	Desc	ription of work order update or non-conformance	ı	nitial iief Eng	Actio Descrip		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												
						FA	ULT CA	TEGORY				
Landing	Bending Centre N Cracks Crimp/Ki Cuffs Crushing Heat Treat Inspection Marks/Cl	at on Strip in	e/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misrea Off-set	ion Incomplete/Unq tions Incomplete/Un gned/off center eled d	· -	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tv	vist in Tuk	be		Fit/Function		Out of	Sequence				

February-12-14 8:36:42 AM

Work Order ID: 113123

113123

Parent Item:

D3535-15

D3535-15

Parent Item Name:

Stainless Steel Wearplate Fwd

Start Date: 2/18/14

Required Date: 2/18/14

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No		100	sf	134.1019	1.0205	- 8.593684	-		
M304S20	NGA							**		A	e 0	2-28-1

Location Loc Qty Loc Code MAT020 134.1018948 m126852 0.91 m127454 133.191895

128315 -> 8.6

DQA:		Date:										TOACT
		_			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			—	AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	
Work Orde	r:				DISPOSITION			AGA	NINST DE	PARTMENT	PROCESS	
					Rework			Skid-tube Cross	stube]	Water Jet	Engineering
Part N	lo.				Scrap			—	ll Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		1	<u> </u>	shing	-1	e/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab Comp	osite		Supplier	
							<u> </u>					
Root				Desci	ription of work order update	1	Initial	Action		Sign &		
Cause	Dat	e Step	Qty	<u></u>	or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design	_											
Doc/Data	_				,							
Equip/Tooling	_											
Handling/Pre	_											
Material	_											
Operator					•							
Offset/Setup						İ						
Process	[,				•		:	
Supplier	_											
Training												
Transport												
Unapproved			_[EAI	III T CA	L Tegory				
Landir	ng Gear				General	- A	OLI CA	ILGON				
[Bendi	nσ			Bend		Teolio/F	Program		Outside Dim	ensions	Pressure/Forced
		e Not Conce	entric		BOM/Route	\vdash	Grain	10514111		Over/Under		Set-up
Ì	Crack				Broken/Damage/Defect	-	Hardwa	are	ļ	Part Incorred		Temperature/Cure
	_	/Kink/Rippl	e/Wave		Burrs		-i	ion Incomplete/Unqualifie	a F	Part Lost/Mi		Weld
ļ	Cuffs	, , , , ,			Contamination	一	1	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crush	ing			Countersink		-	gned/off center	F	Positioned V	ــــــ Vrong	, , , , , , , , , , , , , , , , , , , ,
	Heat	Treat			Cut Too Short		Mislab			Power Loss/	_	Other
	Inspe	ction Strip in	n Tube		Drawing	Г	Misrea	d	<u> </u>	.		
	Mark	/Chatter			Drill Holes	Г	Off-set					
	Turni	ng Sequence	9		Finish		Out of	Calibration				
	Wave	/Twist in Tu	be		Fit/Function		Out of	Sequence				***

DART AEROSPACE LTD	Work Order:	113123
Description: Wearshoe	Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

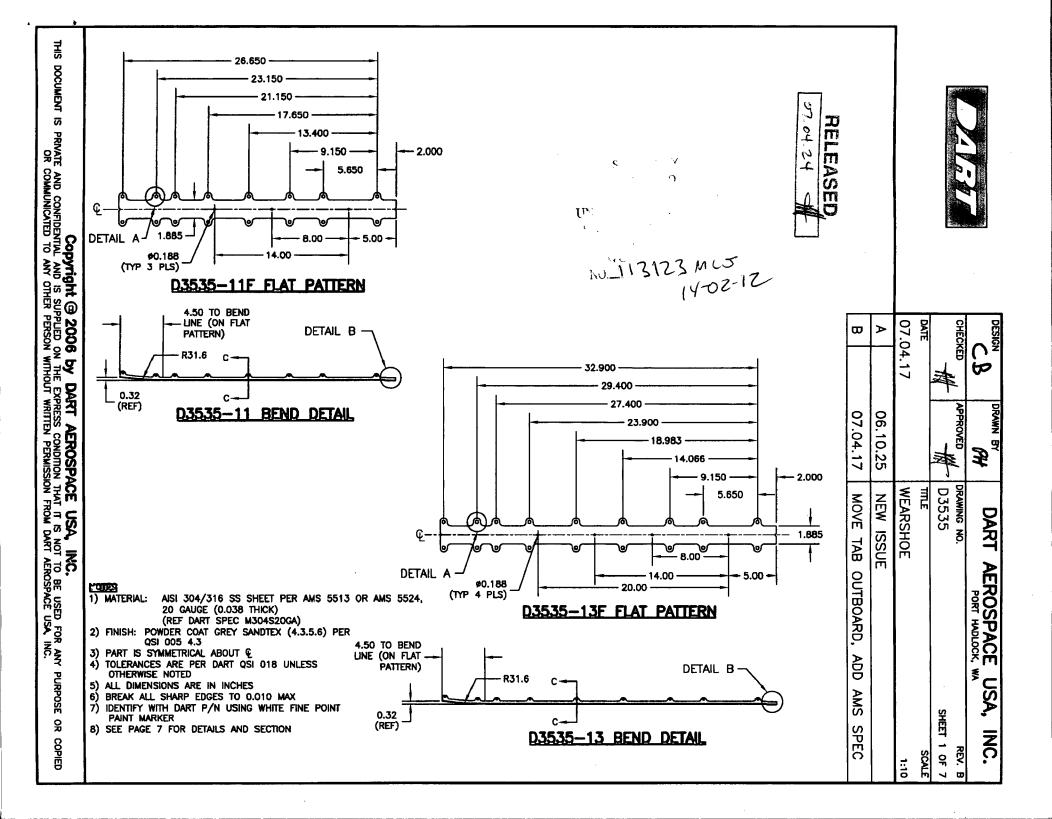
X First Article Prototype

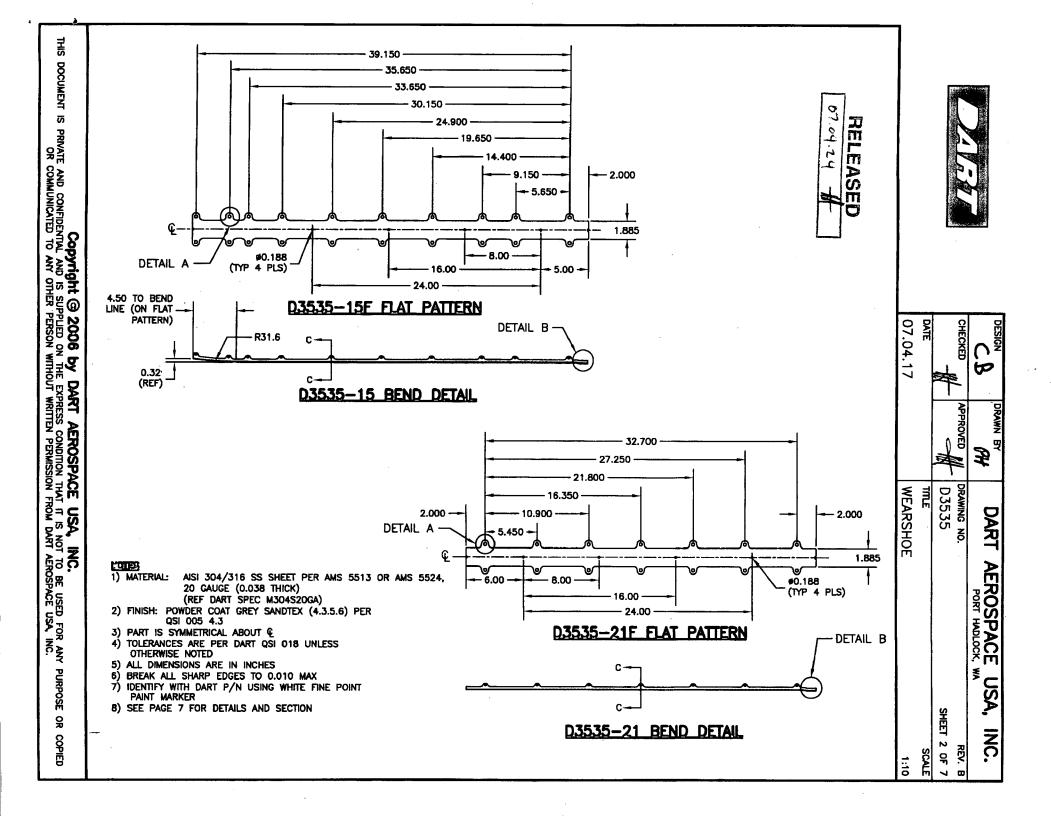
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.887	_		V	JKm-05
2.000	+/-0.010	2000	-		7	JKm.db
5.650	+/-0.010	5.650	_			
9.150	+/-0.010	9.150	_		T	
14.400	+/-0.010	14.400	_		٢	
19.650	+/-0.010	19.650	_		7	
24.900	+/-0.010	24.900	_		T	
30.150	+/-0.010	30.150	_		1	
33.650	+/-0.010	33,650	_		~	
35.650	+/-0.010	35,680	_		1	
39.150	+/-0.010	39.150	~		T	
Ø0.188	+0.005/-0.001	.188	com-		V	
24.00	+/-0.030	24.00	_		7	
16.00	+/-0.030	16.00	~		+	
8.00	+/-0.030	8.00			T	
5.00	+/-0.030	5.00	_	_	T	
0.300	+/-0.010	300	_		>	
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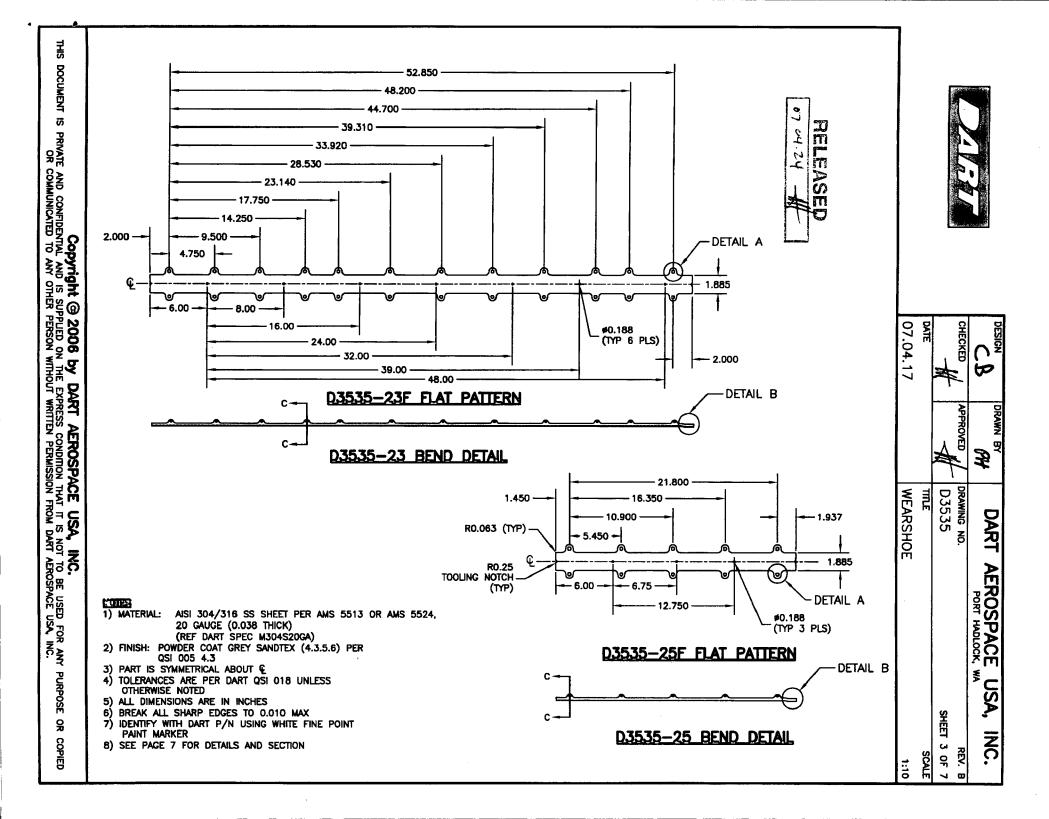
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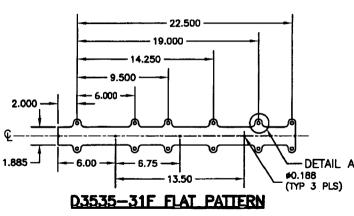
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Date: 02-28.14	Date:	14/3/3	Date:	N/A

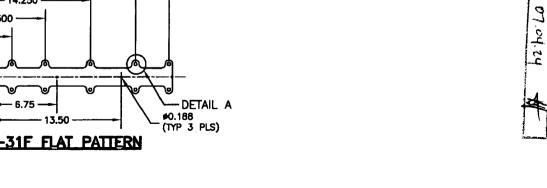
Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM 🛠	E



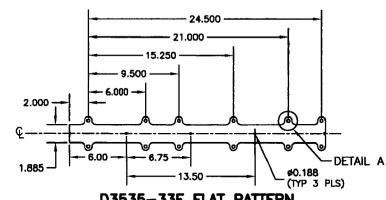




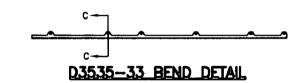








D3535-33F FLAT PATTERN



LOIDS.	
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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



CHECKED

D

B

DART

AEROSPACE

RC.

DRAWING NO. D3535

SHEET

4 OF 7

SCALE 1:10

07.04.17

WEARSHOE

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DATE

CHECKED

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3

DART

AEROSPACE PORT HADLOCK,

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RC.

D3535 DRAWING NO.

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SCALE 읶

1:10

07.04.17

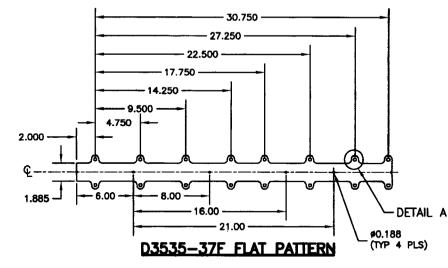
WEARSHOE

JAN III ASK

23.250 17.750 14.250 9.500 4.750 2.000 #0.188 (TYP 2 PLS) DETAIL A

D3535-35F FLAT PATTERN





1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

PART IS SYMMETRICAL ABOUT &

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



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DOCUMENT

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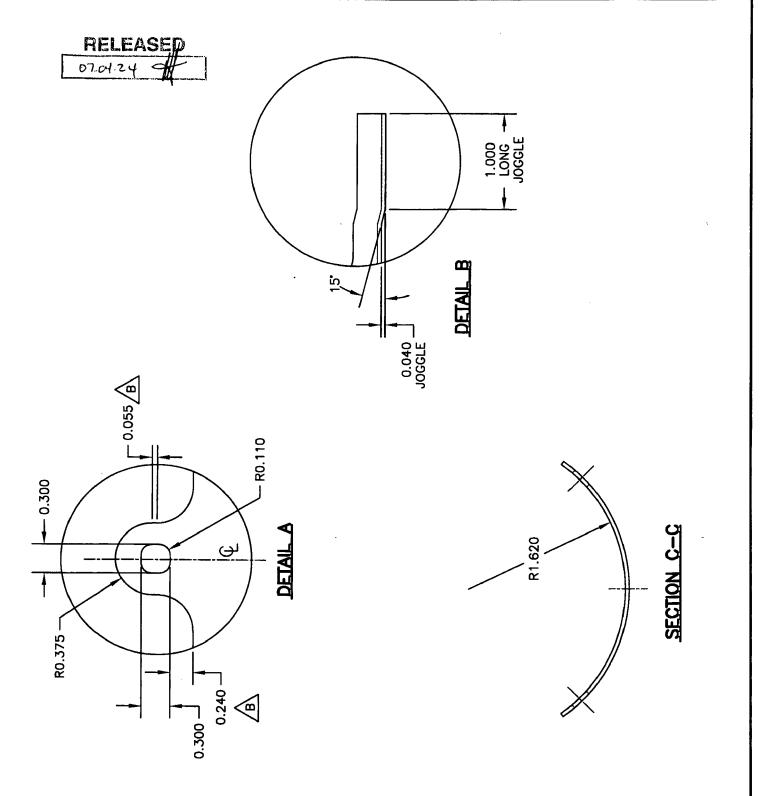
PURPOSE

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DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED **	APPROVED #/	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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